

BLUE

Work Order ID 62602

October 5, 2010 10:29:06 AM



Item ID: D206-667-203BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Aft, Blue

Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/19/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 10/10/10 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D206-667-243

C

Pro →

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D206-667-203 CHG003

6

110

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D206-667-243 using CNC bender program D206-667-203

R 10-10-13

(X1)

120

0.00



QC15- Crosstube Dimensional Check

QC

Memo

0.00

Quality Control

Siobhain

(X1)

Signature

| W/O: 62602 | | WORK ORDER CHANGES | | | | | |
|------------|-------|---|--------------------|----------|-----|-------------------------------------|--------------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 10/10/28 | # 100 | Per. change ADD Routing #'s for parts to be picked in correct sequence | <i>[Signature]</i> | 10.10.28 | | | <i>[Signature]</i> 10/10/28 |
| | | | | | | | |

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 Crosstubes | Crosstubes | 0.00 | | | | | | | |
| Crosstubes | Memo 1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 and drill table DT8577 and tower holes #6 as per QSI0010 and as per Dwg D206-667-243. Drill all (3) top holes. 2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243 Check dimensions between holes on all four sides. 3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. 4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes. 5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243 6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes. 7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243. 8-C'sink holes as per Dwg D206-667-243. 9 -Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243 Inside of Cuff(Donot engrave on outside of tube) 10 -Deburr & Inspect for surface damage. Repair damage within limits as per | 0.00 | | | | | | | |

SAD

10-10-14

→ EL

10-10-14

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Dwg
D206-667-243

140



HandFXtube

Crosstubes Chemical Conversion

0.00

SAD
10-10-18

Memo

0.00

①

Hand Finishing Crosstubes

150



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

1

10/10/20

Quality Control

160



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

1

10/10/20

Quality Control

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| 170 | Outsource process - NDT per QSI038 4.1 | 0.00 | | | | | | | |
| Outsource2 | Memo | 0.00 | | | | | | | |
| Outsource process - NDT | Liquid Penetrant Inspection as per QSI 038Or Issue P/O: <u>12783</u> LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order | | | | | | | | |
| 180 | Packaging | 0.00 | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Ensure copy of NDT results attached to work order. | | | | | | | | |
| 190 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | Ensure results are as per Dwg D206-667-243 | | | | | | | | |

CL 10/10/21 ①

P. 10/10/21 ①

MA 10 10 25 ①

Dart Aerospace Ltd

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200

0.00



SprayPaint

SprayPaint

Memo

0.00

1-Prime inside and outside crosstube as per QSI 005 4.2
2-Paint outside crosstube with ~~White~~ Iron as per QSI 005 4.2

B 114424

PRIME:

Start Time: 9:30
Finish Time: 10:30

Deflat Blue B 115509
clear Deflat B 115506

PAINT:

Start Time: 2:30
Finish Time: 3:30

ml 10 10 25 (1)

210

0.00



QC14- Inspet Spray Paint

QC

Memo

0.00

Wrap in plastic bag to protect from scratches

10 - 10 - 26 (1)

Quality Control

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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

220

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1-Install nut plates as per Dwg D206-667-243.

ml 10 10 26 (1)

230

0.00



Skidtubes

Crosstubes

Memo

0.00

Crosstubes

1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI 015. Let cure for 12h after installation and prior to packaging. Note: (3) top holes should be facing up.

A/R Magnobond 6398 : 114158 exp: 01/2011

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

ml 10 10 27

ml 10 10 26 (1)

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|-----------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 240 QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | | | | |
| 250 Packaging Packaging | Pick Kit Memo | 0.00 0.00 | | | | | | | |
| 260 QC Quality Control | QC4- 100% Inspect kits for completeness Memo | 0.00 0.00 | | | | | | | |

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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

270

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-667-203

Location: 114PPP Rev: D

01/14/28 SP

280

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

10/10/28 MF
10-10-28

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Picklist Print

October 5, 2010 10:29:05 AM

Page 1

Work Order ID: 62602

Parent Item: D206-667-203BL

Parent Item Name: Crosstube Aft, Blue

Start Date: 10/05/10

Required Date: 10/19/10

Start Qty: 1.00

Required Qty: 1.00

Comments:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|----------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|----------------|--------------|---------------|----------------|--------|

AN5-10A

Purchased

No

Each

305.0000

10

10



Bolt

Location

Loc Qty

Loc Code

ST337

305

115108

18

115429

50

115589

100

115700

137

AN5-32A

Purchased

No

Each

300.0000

4

4



Bolt

Location

Loc Qty

Loc Code

ST340

300

114056

40

114405

50

115016

50

115108

50

115589

60

115698

50

AN5-34A

Purchased

No

Each

68.0000

4

4



Bolt

Location

Loc Qty

Loc Code

ST340

68

113149

2

113226

46

115835

20

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Start Date: 10/05/10

Required Date: 10/19/10

Start Qty: 1.00

Required Qty: 1.00

AN960JD516 NAS1149D0563J Purchased No

Each 34.0000 18



Washer



18
M114742 10/10/10

Location

Loc Qty

Loc Code

ST
103694
107534
109287

34
18
12
4

D206-667-203TRN Manufactured No

Each 2.0000 1



Crosstube Turning Detail



1
SAD 10-10-13

Location

Loc Qty

Loc Code

LG
61983
62029

2
1
1

D2873-043 Manufactured No

Each 16.0000 2



Nut Plate Assembly



2
M10 10 10 26

Location

Loc Qty

Loc Code

ST
60981

16
16

D2873-045 Manufactured No

Each 14.0000 2



Nut Plate Assembly



2
M10 10 10 26

Location

Loc Qty

Loc Code

LG
60982

14
14

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Parent Item Name: Crosstube Aft, Blue

Start Date: 10/05/10

Required Date: 10/19/10

Start Qty: 1.00

Required Qty: 1.00

D2892-1 Manufactured No

Each 32.0000 2 2



m/ 10-10-26

Support

Blue

R# 62592

Location

Loc Qty

Loc Code

LG

32

41986

12

42785

20

D3595-063-450 Manufactured No

Each 91.6590 4 4



m/ 10-10-26

RUBBER CUSHION

Location

Loc Qty

Loc Code

LG

91.65897368

53775

5.97897368

58161

3.56

59580

10.12

61465

72

MS20601-AD4W10 Purchased No

Each 32.0000 14 14



m/ 10-10-26

RIVET

Location

Loc Qty

Loc Code

LG051

18

114245

2

115405

16

ST322

14

13220

14

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Shop Packet Print

Page 3

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NOTE: Date & initial all entries

Picklist Print

Page 4

October 5, 2010 10:29:05 AM

Work Order ID: 62602



Parent Item: D206-667-203BL



Parent Item Name: Crosstube Aft, Blue

Start Date: 10/05/10

Required Date: 10/19/10

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

Each

899.0000



4 4
10/10/27 SP

Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

873

115156

373

115594

500

4

MS21920-22

Purchased

No

Each

62.0000



4

ml 10.10.26

Clamp(per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

LG

62

114077

62

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

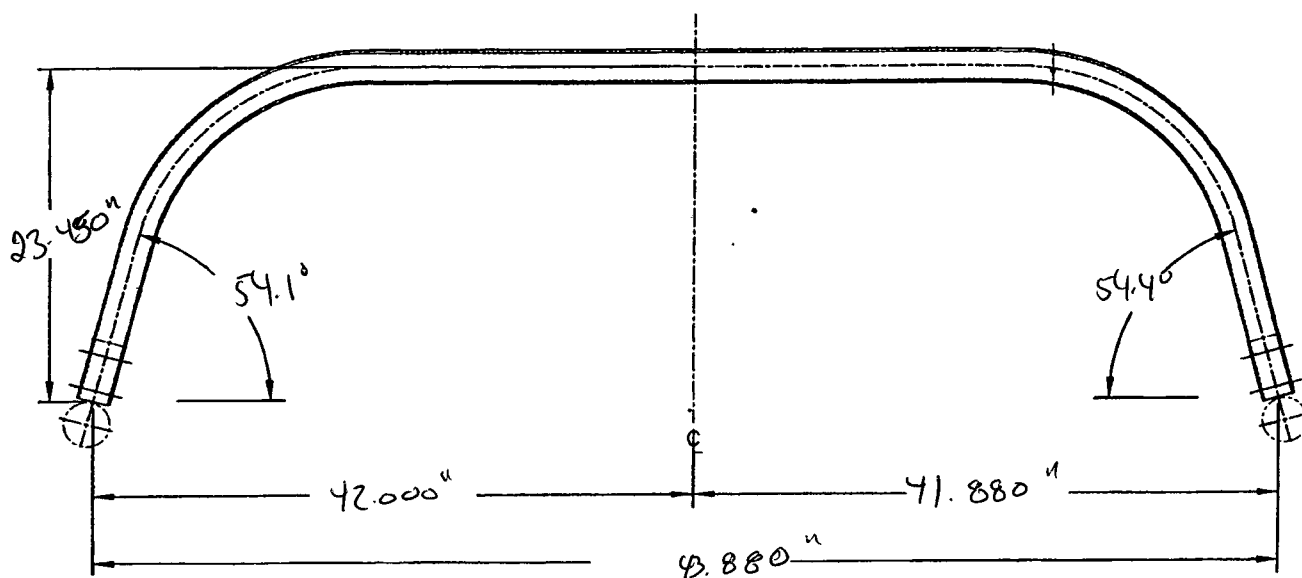
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | |
|---|----------------------------------|
| DART AEROSPACE LTD | Work Order: 62600 |
| Description: Crosstube High Aft (206L) | Part Number: D206-667-203 |
| Inspection Dwg: D206-667-243 Rev: C | Page 1 of 1 |

| Required Dimension | Min | Max |
|--------------------|-------|-------|
| Height | 23.39 | 23.65 |
| 1/2 Span | 41.79 | 42.05 |
| Angle | 54 | 56 |
| Total Span | 83.58 | 84.1 |



| Comments |
|----------|
| |
| |
| |
| |

| | |
|-----------------|----------|
| QC15 Inspection | S |
| Date | 10/10/14 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---------------------------------|------------|----------|
| A | 07.02.06 | New Issue | KJ/JM | |
| B | 09.11.17 | Dwg Rev updated | KJ | |
| C | 09.12.14 | Dimensions update per Dwg Rev C | KJ | |

| Item | Qty | Part Number | Description |
|------|------|----------------|--|
| | -243 | | |
| 1 | X | D206-667-243 | CROSSTUBE ASSEMBLY (206L HIGH AFT) |
| 2 | 1 | D6004-115 | CROSSTUBE |
| 3 | 2 | D2873-043 | NUT PLATE |
| 4 | 2 | D2873-045 | NUT PLATE |
| 5 | 2 | D2892-1 | SUPPORT |
| 6 | 4 | D3595-063-450 | RUBBER CUSHION |
| 7 | 4 | MS21920-22 | CLAMP |
| 8 | 14 | MS20601AD4W10 | RIVET (OR NAS9302B-4-10) |
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE) |

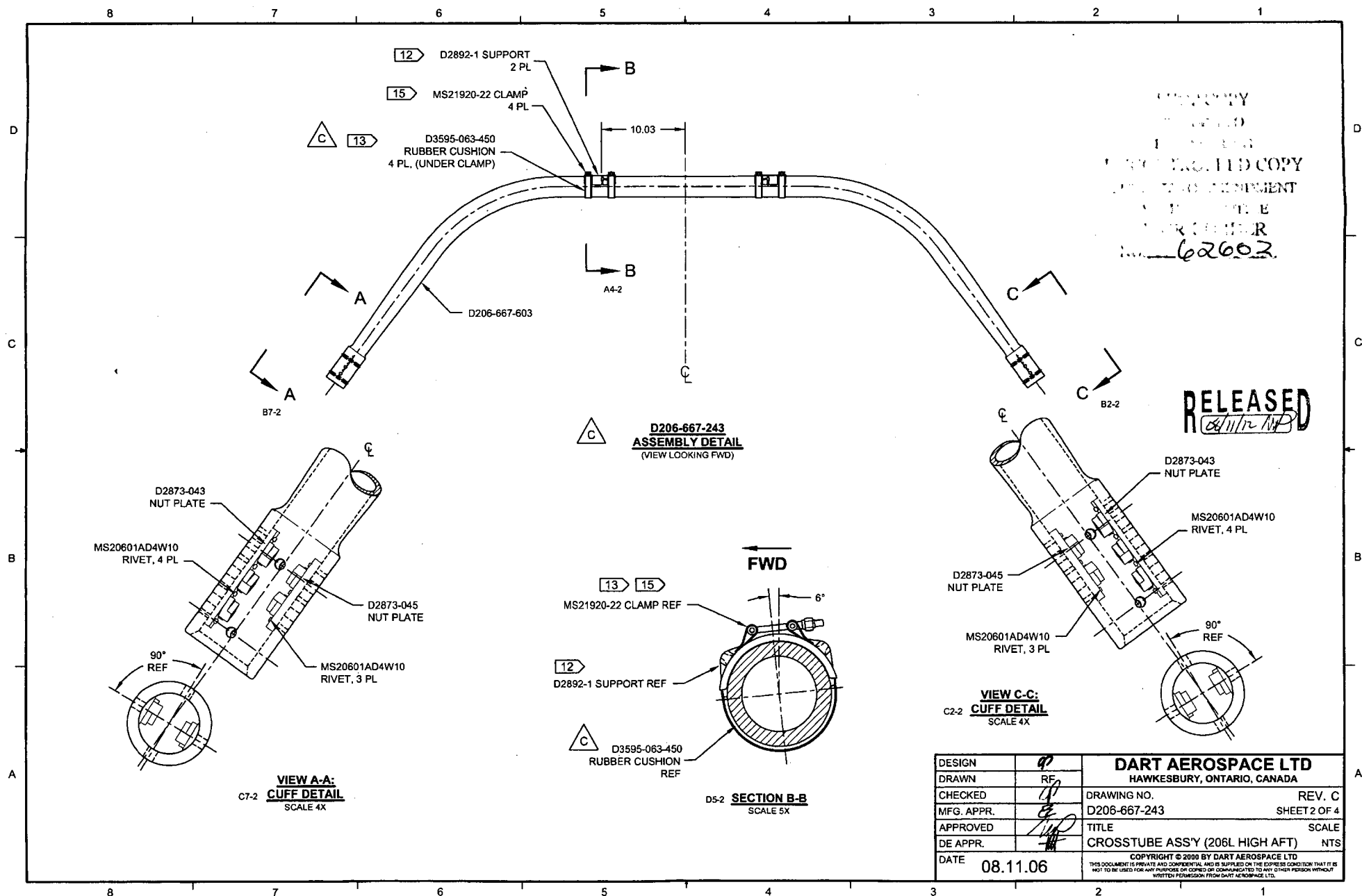
GENERAL NOTES:

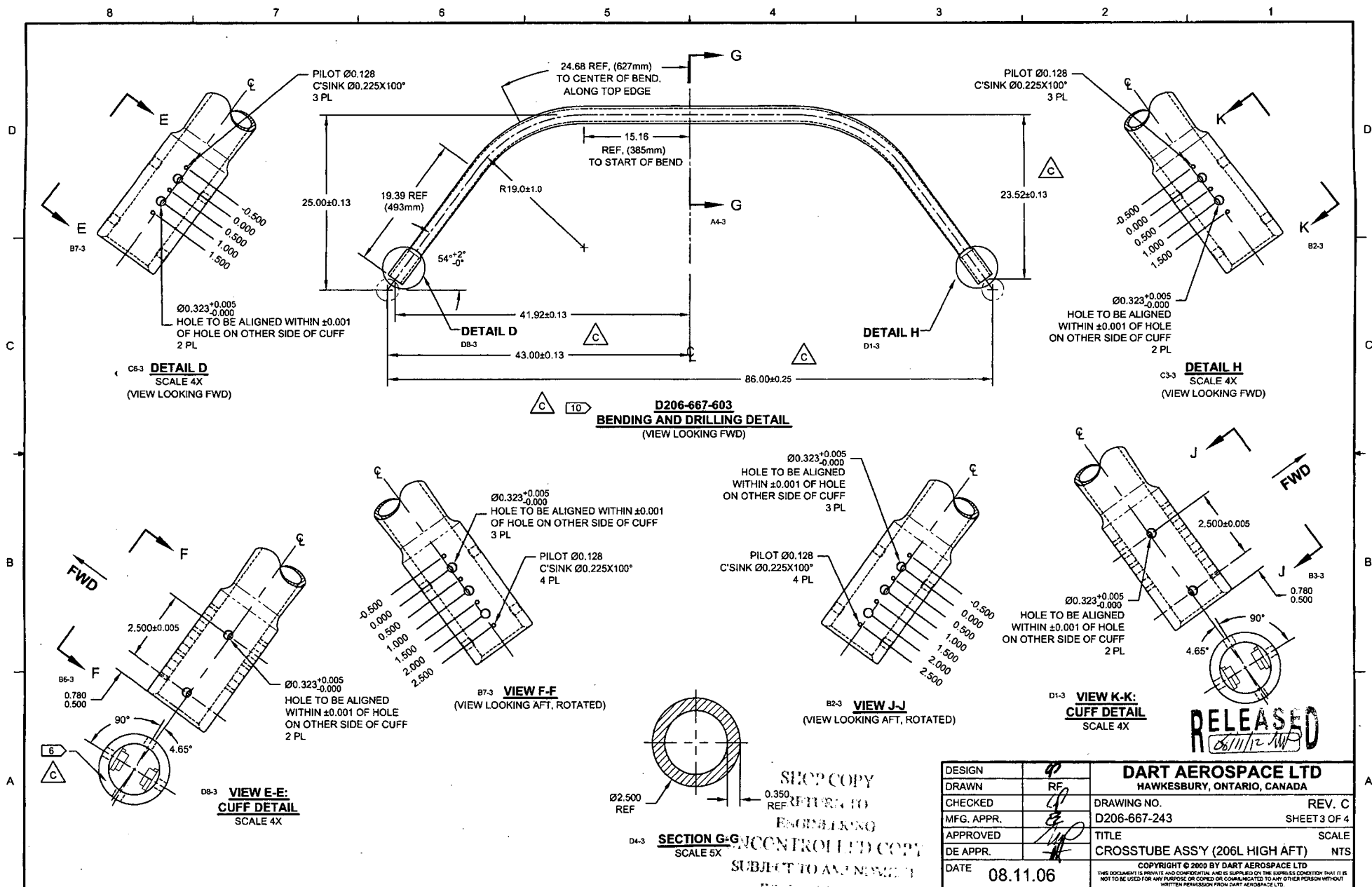
- 1) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-243" AND BATCH NUMBER ON
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 21.9 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE
D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE
LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SAFETY
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT OF MINIMUM
VOLUME
WARRANTY
DATE 062602
CZ10/10/05

RELEASED
06/11/05

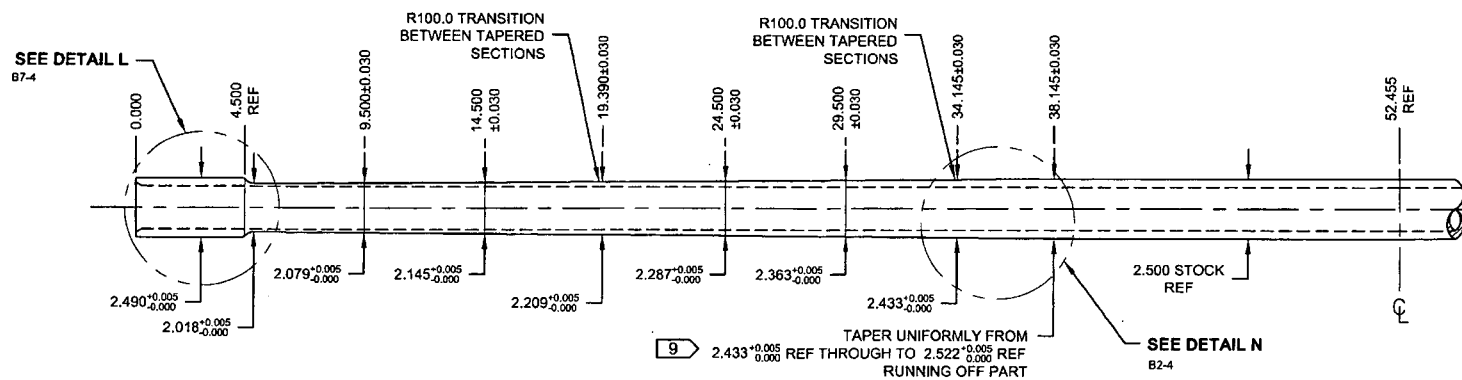
| | | | |
|------------|---|---|--------------|
| C | REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-450 WAS D2856-400-773 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN 4-3, C5-3, D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210: MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4. | RF | 08.11.06 |
| B | ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES | PH | 05.07.26 |
| A | NEW ISSUE | CP | 00.11.17 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | DRAWING NO. | REV. C |
| CHECKED | RF | D206-667-243 | SHEET 1 OF 4 |
| MFG. APPR. | RF | TITLE | SCALE |
| APPROVED | RF | CROSSTUBE ASS'Y (206L HIGH AFT) | NTS |
| DE APPR. | RF | COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DATE | 08.11.06 | | |



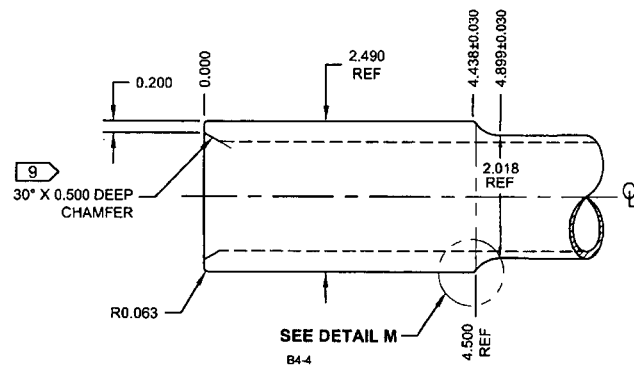


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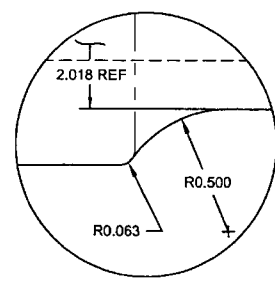
NO. 62602



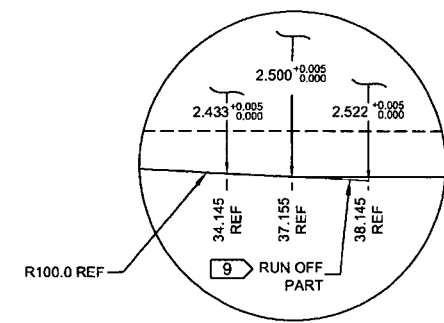
C TURNING DETAIL



C7-4 **DETAIL L: CROSSTUBE CUFF**
NOT TO SCALE



B6-4 **DETAIL M: CUFF TRANSITION**
NOT TO SCALE



C4-4 **DETAIL N: TAPER RUN-OFF**
NOT TO SCALE

RELEASED
08/11/06

| | | | |
|---|----------|--|--------------|
| DESIGN | 9 | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JP | DRAWING NO. | REV. C |
| MFG. APPR. | JP | D206-667-243 | SHEET 4 OF 4 |
| APPROVED | JP | TITLE | SCALE |
| DE APPR. | JP | CROSSTUBE ASSY (206L HIGH AFT) | NTS |
| DATE | 08.11.06 | COPYRIGHT © 2000 BY DART AEROSPACE LTD | |
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5.0 PARTS LIST

| Item | Qty -011 | Qty -013 | Qty -015 | Qty -101 | Qty -201 | Qty -103 | Qty -203 | Qty -105 | Qty -205 | Part Number | Description |
|------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|--|
| | X | | | | | | | | | D206-667-011 | SPACER BLOCK KIT |
| | | X | | | | | | | | D206-667-013 | NUT PLATE KIT (-101/-103/-105/-203/-205) |
| | | | X | | | | | | | D206-667-015 | NUT PLATE KIT (-201) |
| | | | | X | | | | | | D206-667-101 | CROSSTUBE INSTALLATION, 206A/B HIGH FWD |
| | | | | | X | | | | | D206-667-201 | CROSSTUBE INSTALLATION, 206A/B HIGH AFT |
| | | | | | | X | | | | D206-667-103 | CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH FWD |
| | | | | | | | X | | | D206-667-203 | CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH AFT |
| | | | | | | | | X | | D407-667-105 | CROSSTUBE INSTALLATION, 407 HIGH FWD |
| | | | | | | | | | X | D407-667-205 | CROSSTUBE INSTALLATION, 407 HIGH AFT |
| 1 | | | | 1 | | | | | | D206-667-141 | CROSSTUBE ASSEMBLY, 206A/B HIGH FWD |
| 2 | | | | | 1 | | | | | D206-667-241 | CROSSTUBE ASSEMBLY, 206A/B HIGH AFT |
| 3 | | | | | | 1 | | | | D206-667-143 | CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH FWD |
| 4 | | | | | | | 1 | | | D206-667-243 | CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH AFT |
| 5 | | | | | | | | 1 | | D407-667-145 | CROSSTUBE ASSEMBLY, 407 HIGH FWD |
| 6 | | | | | | | | | 1 | D407-667-245 | CROSSTUBE ASSEMBLY, 407 HIGH AFT |
| 10 | | | | *2 | *2 | *2 | | *2 | | D2891-1 | SUPPORT |
| 11 | | | | | | | *2 | | | D2892-1 | SUPPORT |
| 12 | | | | | | | | | *1 | D2894-1 | SUPPORT |
| 13 | | | | *2 | *2 | *2 | | *2 | | D2856-400-694 | ABRASION STRIP |
| 14 | | | | | | | *2 | | *2 | D2856-400-773 | ABRASION STRIP |
| 15 | | | | | | | | | *1 | D2856-600-851 | ABRASION STRIP |
| 16 | | | | *4 | *4 | *4 | | *4 | | MS21920-20 | CLAMP |
| 17 | | | | | | | *4 | | *4 | MS21920-22 | CLAMP |
| 18 | | | | | | | | | *2 | MS21920-24 | CLAMP |
| 19 | | | | 4 | 4 | 4 | | 4 | | AN5-32A | BOLT |
| 20 | | | | | | | 4 | | 4 | AN5-34A | BOLT |
| 21 | | | | 4 | 4 | 4 | 4 | 4 | 4 | MS21042L5 ✓ | NUT (OR MS21042-5) |
| 22 | | | | 8 | 8 | 8 | 8 | 8 | 8 | AN960JD516 | WASHER |
| 23 | | | | | | | | | *2 | D3190-1 | CHAFING SHIELD |
| 30 | 8 | | | | | | | | | AN4-6A | BOLT |
| 31 | 8 | | | | | | | | | AN4-7A | BOLT |
| 32 | 16 | | | | | | | | | AN960JD416 | WASHER |
| 33 | 2 | | | | | | | | | D3193-041 | SPACER BLOCK ASSEMBLY |
| 40 | | 2 | | *2 | | *2 | *2 | *2 | *2 | D2873-043 | NUT PLATE |
| 41 | | 2 | | *2 | | *2 | *2 | *2 | *2 | D2873-045 | NUT PLATE |
| 42 | | | 2 | | 2 | | | | | D2872-043 | NUT PLATE |
| 43 | | | 2 | | 2 | | | | | D2872-045 | NUT PLATE |
| 44 | | 10 | | 10 | | 10 | | | | AN5-7A | BOLT |
| 45 | | 10 | 10 | | 10 | | 10 | 10 | 10 | AN5-10A | BOLT |
| 46 | | 4 | 4 | 4 | 10 | 4 | | 4 | | AN5-30A | BOLT |
| 47 | | 4 | | | | | 4 | | 4 | AN5-32A | BOLT |
| 48 | | 18 | 18 | 10 | 12 | 10 | 10 | 10 | 10 | AN960JD516 ✓ | WASHER |
| 49 | | 4 | 4 | | 6 | | | | | MS21042L5 | NUT (OR MS21042-5) |

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-141/241/143/243, & D407-667-145/245 ASSEMBLIES ABOVE

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Revision: C
Date: 05.07.26

Page 1 of 1

Description CROSSTUBE INSTALLATION (206L HIGH AFT)

[illegible]

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



LIQUID PENETRANT TEST REPORT

P- 15031

PAGE 1 OF 1

CLIENT Dart Aerospace DATE Oct 21st 2010 TIME AM ☒ PM ☐
ATTENTION Linde Lacelle ACUREN JOB NO. 188-10-0927
ADDRESS 1270 Aberdeen St. POWO No. [12783]
Hawkesbury WORK LOCATION Hawkesbury
ACCEPTANCE STD. ASTM 1417/1418-03E REV./DATE 2005
PROJECT x-tubes # D206-667-203BL and D206-667-103BL
ITEM(S) EXAMINED Job #'s : 62598, 62599, 62602, 62605, 62606, 62607

JOB DESCRIPTION PROCEDURE NO. LT- REV./DATE TECHNIQUE NO. LT- REV./DATE
PART NO. D206-667-203BL, D206-667-103BL MATERIAL ALODINED ALUM THICKNESS N/A
SCOPE WET FLUORESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE OF X-TUBES

TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNAFLUX BLACK LIGHT S/N 8178 ☒ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT ZLC7 MINIMUM DWELL TIME 1045 MIN. LIGHTING EQUIP. ☒ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H2O MINIMUM DRY TIME > 10 MIN. OTHER CAL OCT 15th 2010
DEVELOPER SKIDSS2 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE April 2011
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/ 50°F ☒ 10°C/ 50°F TO 52°C/ 125°F ☐ > 52°C/ 125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

WET FLUORESCENT LIQUID
PENETRANT INSPECTION
CARRIED OUT ON 100%
EXTERNAL SURFACE ON X-TUBES:
Job #'s: 62598: ACCEPTABLE
62599: ACCEPTABLE
62602: ACCEPTABLE
62605: ACCEPTABLE
62606: ACCEPTABLE
62607: ACCEPTABLE

10 10 75

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Ian Tiley PRINT [Signature] SIGNATURE DTR # E-63200
TECHNICIAN (SIGNATURE): [Signature] REPORT REVIEWED BY:
NAME (PRINT): FREDERICK CHACNON NAME INITIALS
1ST TECHNICIAN 2ND TECHNICIAN
CGSB LEVEL I SNT LEVEL I CGSB LEVEL SNT LEVEL
CGSB REG. No 10560 CGSB REG. No

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